

Work Order ID 66178

Monday, February 07, 2011 11:40:36 AM

Page 1

Item ID: D3247-1

Accept

Revision ID:

Item Name: Angle

Start Date: 2/8/2011 Start Qty: 4.00

Required Date: 2/22/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: CMFDate: 11-02-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3247

Rev A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

2024 . 063

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

B 11-2-17

(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 11-2-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

*NOTE: Date & initial all entries

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Item ID: D3247-1

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Setup Start



Revision ID:

Stop



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Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

M 11 02 17 (6)

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

SB 11/02/17

(6)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/17

(6)

W/O:		WORK ORDER CHANGES					
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Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 2/8/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6 0 11/02/22

155

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

M 112588

Memo

0.00

Powder Coating

START TIME: 3:15.
OVEN TEMP: 325°
FINISH TIME: 3:45.

6 0 11-2-23.

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 0 11/02/24

W/O:		WORK ORDER CHANGES						
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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/2/24

60 \$

11/02/25

mf
11-02-24

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, February 07, 2011 11:40:34 AM

Page 1

Work Order ID: 66178



Parent Item: D3247-1



Parent Item Name: Angle

Start Date: 2/8/2011


Required Date: 2/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B 04.10.26 D3247-1 no longer made in-house
10.12.06 NOW MADE IN HOUSE DD VERF:EC

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063  2024-T3 .063 sheet		Purchased	No			100	sf	31.9270	0.2347	0.988211			



B 11-2-17

Location

Loc Qty

Loc Code

MAT22

31.927

114351

31.927

114351

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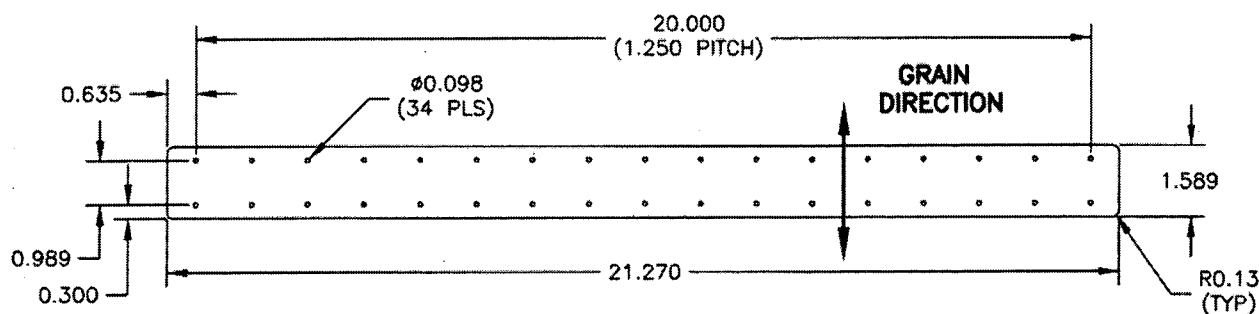
NOTE: Date & initial all entries



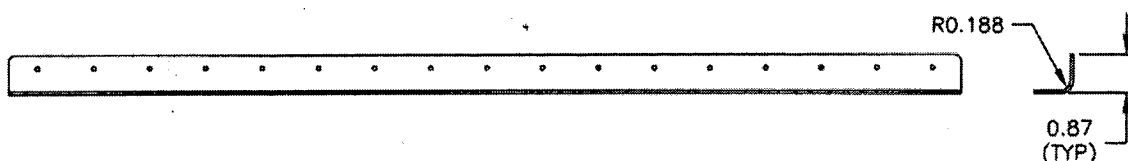
DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED RT	DRAWING NO. D3247	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE ANGLE	SCALE 1:4
A	04.04.06	NEW ISSUE	

RELEASED
04.04.27

#66178



FLAT PATTERN



D3247-1 BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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